

**Work Order ID 59207**

Friday, May 28, 2010 9:19:25 AM

Page 1

Item ID: D3911-043 Accept

Revision ID:

Item Name: Aft Eyebolt Receiver Assembly

Start Date: 5/27/2010 Start Qty: 10.00

Required Date: 6/4/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:   H   Date: 10-5-29 Tooling:           QC:            Date:            SPC (Y/N):           

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3911

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110



Small Fab

Memo

0.00

0.00

Small Fab

1- Assemble D3911-5 to D3911-3 and install rivet as per dwg  
Trim rivet to 1.250" Full Length

120



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

S 10/5/29

5/30/07/27 (10)

5/30/07/27 (10)

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

Identify as per dwg & Stock Location: S07

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/7/27 S (100)10/07/28 SR/10-7-27  
(10)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

Friday, May 28, 2010 9:19:31 AM




Page 1

**Abstract**



**Required Date:** 6/4/2010

**Required Qty: 10.00**

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3911-3		Manufactured	No			100	Each	5.0000	1	10			
													
Aft Eyebolt Receiver													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST095			5						
				58787			5						
D3911-7		Manufactured	No			100	Each	7.0000	2	20			
													
Basket Plate-Eyebolt Receiver													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST095			7						
				57838			7						
MS20615-4M20		Purchased	No			100	Each	73.0000	4	40			
													
RIVET													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST323			73						
				113254			7						
				114324			4						
				114349			62						

W/O:		WORK ORDER CHANGES					
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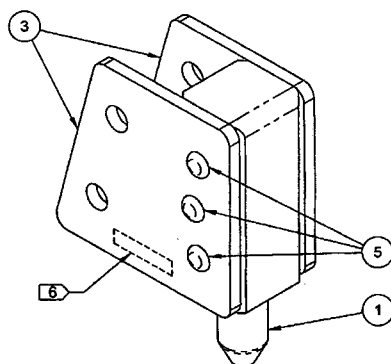
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET



**D3911-041 BASKET INSTL STUD ASSY (LOWER)**

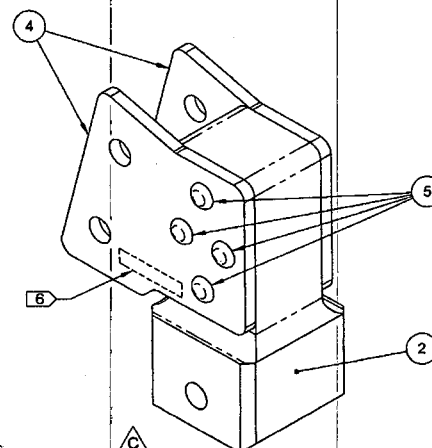
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs  
-043: 0.99 lbs

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 39207

*RI 10-5-28*



**D3911-043 AFT EYEBOLT RECEIVER ASSY**

**RELEASED**  
2010-04-14

C	BOM: QTY (2): D4087-1 & MS21209-C610 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3911	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT HARDPOINT, BASKET	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

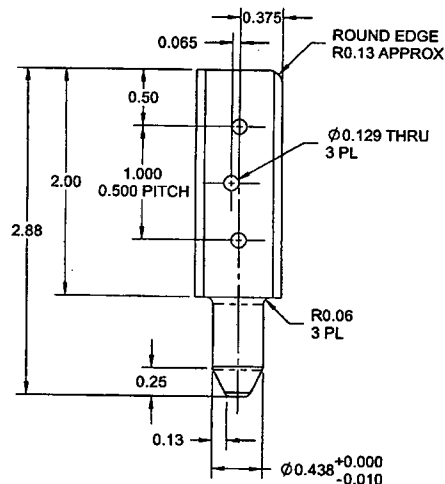
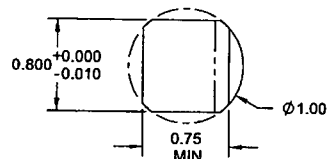
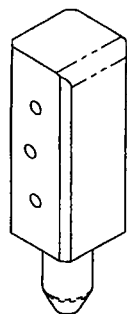
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

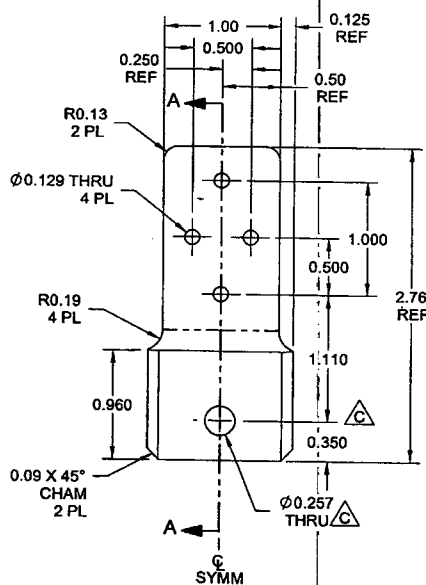
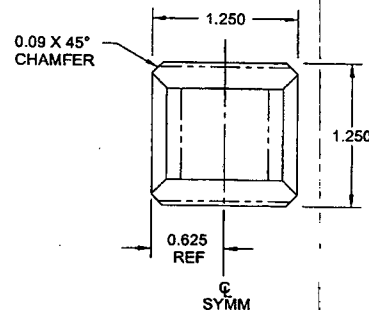
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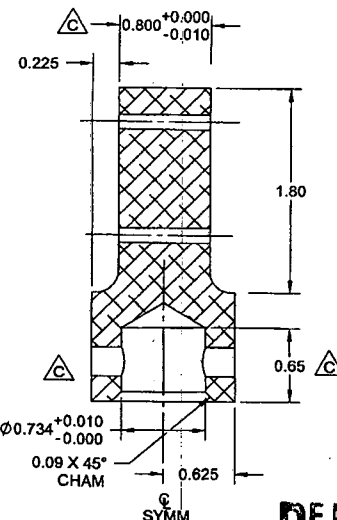
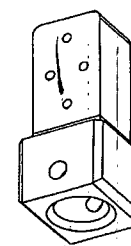




**D3911-1 BASKET INSTL STUD (LOWER)**



**D3911-3 AFT EYEBOLT RECEIVER**



**SECTION A-A**

**RELEASED**  
2010-06-14

**NOTES:**

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303R OR M304R
- 3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs  
-3: 0.73 lbs

W10 59207

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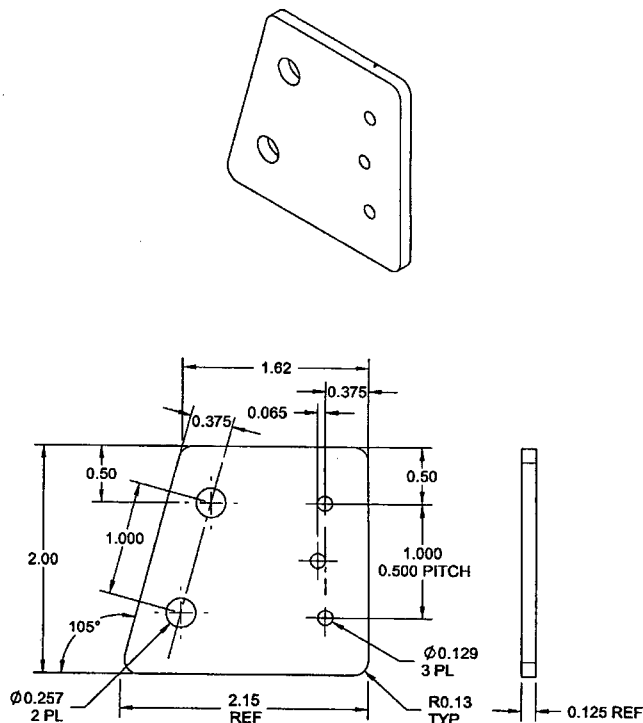
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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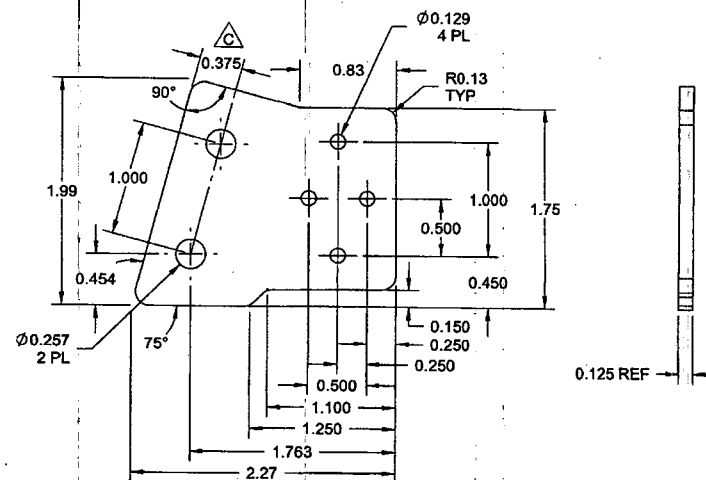
**NOTE:** Date & initial all entries



**D3911-5 BASKET STUD PLATE**

**NOTES:**

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240  
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.13 lbs  
-7: 0.13 lbs



**D3911-7 BASKET PLATE-EYEBOLT RECEIVER**

**RELEASED**  
2010-04-14

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESSBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO. <b>D3911</b>	REV. C
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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